



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4838-2

Job Sheet 197334



Part No: D4838-2

Job Qty: 18 pcs

Part Name: Upper Cutter Body, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/4/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEETS 1,4,5 IPP REV:A NEW ISSUE JFS 13/04/26 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	18 pcs		10/18/19	0.00	0.06	Bandsaw - 1		B. 19-08-29
110	HAAS 4 Axis - B4B	18 pcs		10/18/19	0.80	25.35	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		A. 19-08-29
120	QC 2	18 pcs		10/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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130	QC 8	18 pcs	10/18/19	0.00	0.00	QC 2 - 63	
						QC 2 - 8	19-08-29
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
140	Outsource - 4 - Anodize	18 pcs	10/18/19	0.00	0.00	QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	19/09/20
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						ATG001-VC	5 2019-10-03
150	Packaging 2-1 - Receive - B4B	18 pcs	10/18/19	0.00	0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	16 OCT 16 2019
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	

				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155	QC 66	18 pcs	10/18/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
170	QC 14	18 pcs	10/18/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9

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DAS

40
9-89

OCT 21 2019

					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
180	Packaging 3-1 - Stock - B4B	18	10/18/19	0.00	0.00	Packaging 3 - 1 - B4B
		pcs				Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B
						Packaging 3 - 14 - B4B
						Packaging 3 - 15 - B4B
						Packaging 3 - 16 - B4B
						Packaging 3 - 17 - B4B
						Packaging 3 - 18 - B4B
						Packaging 3 - 19 - B4B
						Packaging 3 - 20 - B4B
						Packaging 3 - 21 - B4B
						Packaging 3 - 22 - B4B
						Packaging 3 - 23 - B4B
						Packaging 3 - 24 - B4B
						Packaging 3 - 25 - B4B
						Packaging 3 - 26 - B4B
						Packaging 3 - 27 - B4B
						Packaging 3 - 28 - B4B
						Packaging 3 - 29 - B4B
						Packaging 3 - 30 - B4B
						Packaging 3 - 31 - B4B
						Packaging 3 - 32 - B4B
						Packaging 3 - 33 -

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				B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	18 pcs	10/18/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 OCT 21 2019
				QC 21 - SA - 53	9-39
Part Op 100 - (Bandsaw) Cut Blank at 4.500" Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB190 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - Issue P/O: <u>44667</u> ATG, black anodize and prime as per dwg D4838-2 Rev. A 150 - (Receive & Inspect for Damage & Mat'l Certs) 155 - (QC5- Inspect part completeness to step on W/O) 170 - (QC14- Inspect Spray Paint) 180 - (Identify as per dwg & Stock Location: <u>ck128</u>) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6B1.000X7.000	7075-T6 Bar 1.000" X 7.000" see mat'l	6.7500 ft (.375 ea)	100-Bandsaw - 1	5056425	
	M7075T6S1.000X7.000				
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M7075T6B1.000X7.000	7	0	0	
Part Specifications					
Specifications could not be found.					

MAT
USED.
6.7500

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DART AEROSPACE LTD		Work Order: 197334
Description: Upper Cutter Body, RH		Part Number: D4838-2
Inspection Dwg: D4838	Rev: A	Page 1 of 1

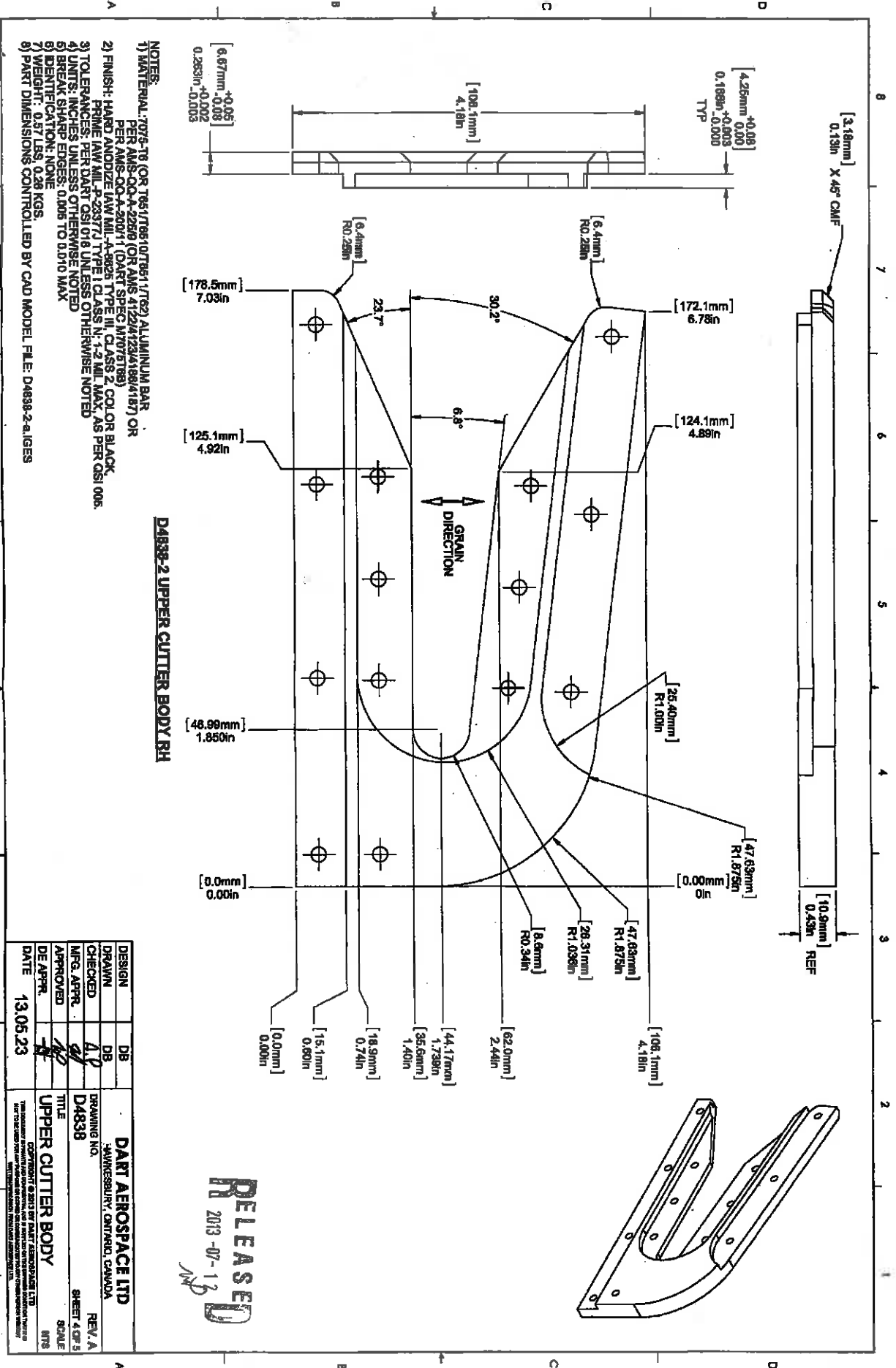
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.130 x 45°	+/-0.030 x +/-0.5°	0.130x45°	✓		Vern	GA-13
4.18	+/-0.030	4.176	✓		H-G	31006
7.03	+/-0.030	7.026	✓		"	"
0.60	+/-0.030	0.597	✓		Vern	GA-13
0.74	+/-0.030	0.747	✓		H-G	31006
1.40	+/-0.030	1.400	✓		Vern	GA-13
2.44	+/-0.030	2.440	✓		H-G	31006
R0.25	+/-0.030	R0.250	✓		R-G	ref.
23.7°	+/-0.5°	23.7°	✓		Angle M.	CNC-17
30.2°	+/-0.5°	30.2°	✓		"	"
0.168	+0.003/-0.000	0.170	✓		D-G	GA-08
0.263	+0.002/-0.003	0.260	✓		Mic	GA-03
0.272	+/-0.010	0.272	✓		H-G	31006
6.625	+/-0.010	6.625	✓		"	"
6.250	+/-0.010	6.250	✓		Vern	GA-13
4.167	+/-0.010	4.167	✓		"	"
1.883	+/-0.010	1.883	✓		"	"
Ø0.177	+0.005/-0.001	Ø0.1775	✓		"	"
0.400	+/-0.010	0.400	✓		"	"
0.360	+/-0.010	0.360	✓		"	"
4.560	+/-0.010	4.560	✓		H-G	31006
2.110	+/-0.010	2.110	✓		Vern	GA-13
2.400	+/-0.010	2.400	✓		"	"

Measured by: B.A.	Checked by: MML	QC Inspector:
Date: 19-08-29	Date: 19/09/20	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	15.10.14	New Issue	KJ	

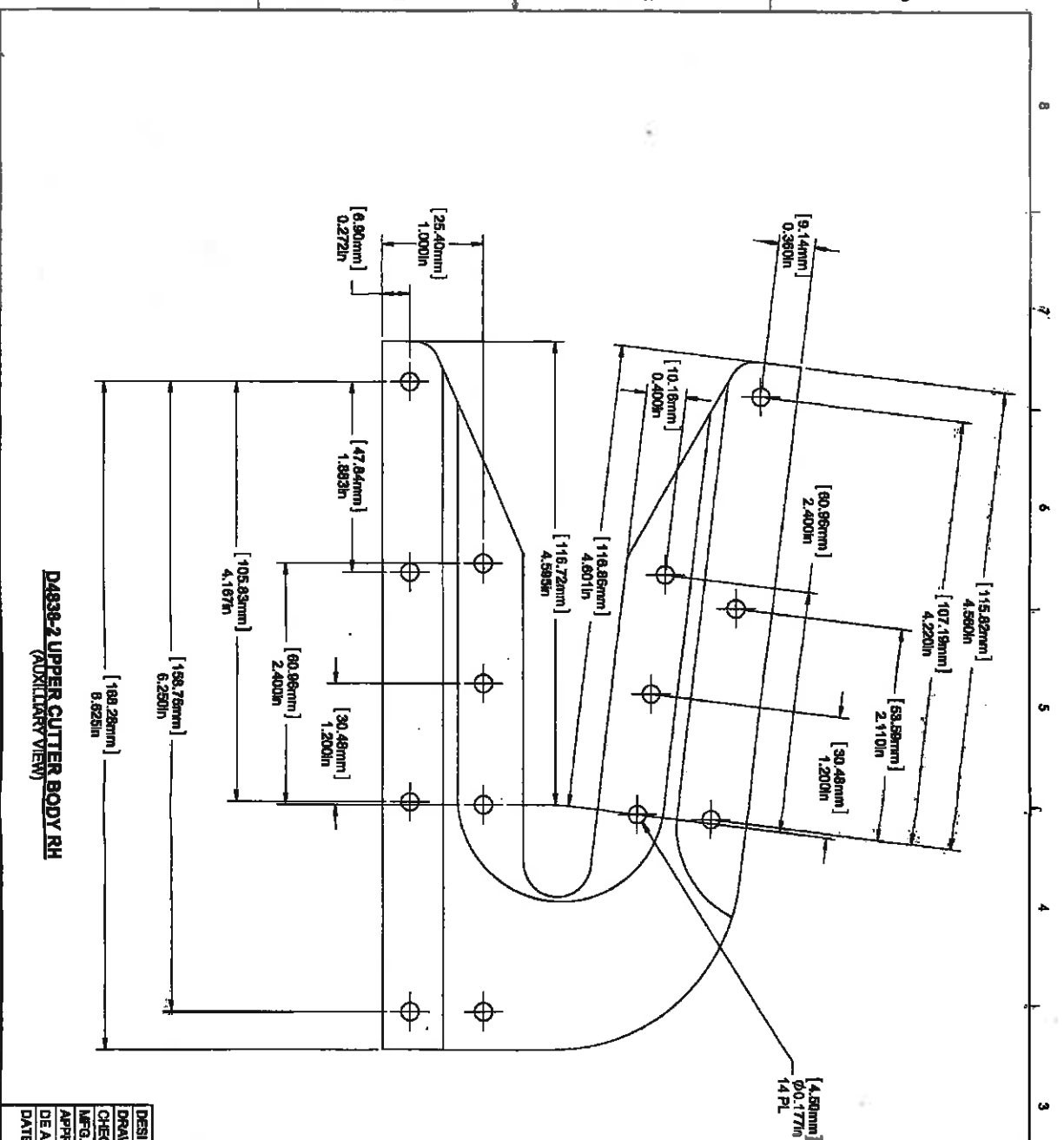


- NOTES:
- 1) MATERIAL: 7075-T6 OR 7075-T651 (7075-T651 ALUMINUM BAR PER AMS-2208 (OR AMS-4122/4123/4186/4187) OR PER AMS-2209 (OR AMS-4124/4125/4188/4189))
 - 2) FINISH: HARD ANODIZED (OR ART SPEC M7075T651)
 - 3) TOLERANCES: PER MIL-STD-C-113 TYPE CLASS N-12 UNLESS OTHERWISE NOTED
 - 4) UNITS: DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK: SQUARE EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.31 LBS 0.28 KGS
 - 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4838-2-IGES

D4838-2 UPPER CUTTER BODY RH

DESIGN	DB	DB	DART AEROSPACE LTD
DRAWN	DB	DB	MANUFACTURED IN CANADA
CHECKED	DB	DB	REV. A
MFG. APPR.	DB	DB	D4838
APPROVED	DB	DB	TITLE
DATE	13.05.23	DB	UPPER CUTTER BODY
		DB	SCALE
		DB	NOTES

RELEASED
R 2013-07-13



D4838-2 UPPER CUTTER BODY RH
(AUXILIARY VIEW)

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	REV. A
MFG. APPR.	af	SHEET 6 OF 8
APPROVED	af	SCALE
DATE	13.05.23	NTS

RELEASE
2013-07-12
ND



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044669**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044669

PO Date: 10/2/19

Due Date: 10/14/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: *REVISED \$*

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201105	RBE350A93-1280-00-01	Block (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed <i>X4</i>	-	10/14/19	4 pcs	0 pcs	4 pcs	\$16.89/pcs	\$67.56
2	200872	RBW6705G02631-3G-1	Lever Rigging Fork, T/R Actuator CLEAR ANODIZE (RED BARN) -Issue P/O to ATG; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Certificate of Conformity is required	Firmed <i>X4</i>	-	10/14/19	4 pcs	0 pcs	4 pcs	\$16.89/pcs	\$67.56



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044669



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	197334	D4838-2	Upper Cutter Body, RH : Various STC's Issue P/O: ATG, black anodize and prime as per dwg D4838-2 Rev. A	Firmed X18	-	10/14/19	18 pcs	0 pcs	18 pcs	\$11.51/pcs	\$207.18
4	200590	646.3719	Doubler : Various STC's (Outsource process-Anodize per QSI017 4:1.10.1) Issue P/O ATG, black anodize and prime as per dwg 646.3719 Rev. A	Firmed X42	-	10/14/19	42 pcs	0 pcs	42 pcs	\$7.51/pcs	\$315.42
5	200589	646.3715	Strut Doubler : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed X31	-	10/14/19	31 pcs	0 pcs	31 pcs	\$7.51/pcs	\$232.81
Grand Total:											\$890.53

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/7/19 9:29 AM Dart.Lavole.Chantal



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918737

Date: 10-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
18 ea	Part: D4838-2 Upper Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26125 PO: POHB044669		Rev: A OCT 16 2019 DASDAS 8140 9-80-89 Expiry Date: 06/20 Line: 3
42 ea	Part: 646.3719 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26126 PO: POHB044669		Rev: A OCT 16 2019 Expiry Date: 06/20 Line: 4
31 ea	Part: 646.3715 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26127 PO: POHB044669		Rev: A OCT 16 2019 Expiry Date: 06/20 Line: 5

Made in Canada.

RECEIVED
OCT 16 2019
DART AEROSPACE LTD.

Made in Canada.

RECEIVED

OCT 16 2019

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918737

Date: 10-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

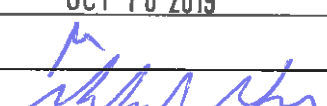
Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 10 2019</u> Certified Signature: <u></u> Receiver Signature: <u></u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. 	
Made in Canada.		